

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015480**Date Inspected:** 08-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Shi Gang.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Subassembly, Bay 09, Gantry# 2, 13CE, Deck Plate to U-rib.

GMAW welding of Partial Penetration weld joints DP3100-001-001 to 008 & 229 to 244; located on Bay 09, Gantry# 2. Welder is identified as 201788, 059416, 059421, 059418; ZPMC Quality Control Inspector (QC) is identified as Chen Shi Gang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5. The attached photographs provide additional detail.

Subassembly, Bay 09, Gantry# 2, 13CE, Deck Plate to U-rib.

GMAW welding of Partial Penetration weld joints DP3105-001-001 to 006 & 138 to 141 & 173, 174, 176 to 181; located on Bay 09, Gantry# 2. Welder is identified as 201788, 059416, 059421, 059418; ZPMC Quality Control Inspector (QC) is identified as Chen Shi Gang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5.

During welding due to some malfunctioning arc strikes on the base metal observed due to which weld metal deposition on the base metal observed at Four (4) locations. ZPMC marked these locations & ZPMC NDT personnel "Sun Gong Chang" carried out Magnetic Particle Testing (MT) at above mentioned locations. ZPMC welded root pass on the same locations & continued the production. The locations & respective weld identification are as follows

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

DP3105-001-138, 139, 140, 141; Y location: 230mm.

For further information, please see the attached pictures below.

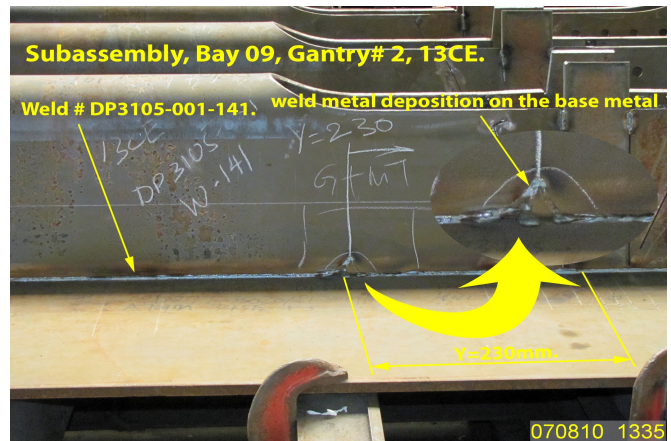
Subassembly, Bay 09, Gantry# 2, 13CE, Deck Plate to U-rib.

SAW welding of Partial Penetration weld joints DP3100-001-001 to 008 & 229 to 244; located on Bay 09, Gantry# 2. Welder is identified as 201788, 059416, 059421, 059418; ZPMC Quality Control Inspector (QC) is identified as Chen Shi Gang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5.

Subassembly, Bay 09, Gantry# 2, 13CE, Deck Plate to U-rib.

SAW welding of Partial Penetration weld joints DP3105-001-001 to 006 & 138 to 141 & 173, 174, 176 to 181; located on Bay 09, Gantry# 2. Welder is identified as 201788, 059416, 059421, 059418; ZPMC Quality Control Inspector (QC) is identified as Chen Shi Gang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Juvekar,Amit

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer